

Work Order ID 160905

Friday, May 05, 2017 9:44:37 AM

160905

Page 1

Item ID: PB67-43001-261

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lever Arm

Start Date: 5/16/2017 Start Qty: 28.00

28

Cust Item ID:

Required Date: 5/22/2017 Req'd Qty: 28.00

28

Customer:

Reference: SCHEDULED/U

Approvals:

Process Plan:

DAS
21
9-09

Date: MAY 05 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001	C

100

0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

6.05

1-Cut as per Dwg B67-43001

Dwg Rev: EProg Rev: E

2-Deburr if necessary

(10)05/17/05/31

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

(10)05/17/05/31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due								
		☐ OTHER :							

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

10

DAS
38
9-89

JUN 01 2017

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

3.53

Hand Finishing

X16

✓

2017/06/10

BEB

140

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

140

Powdercoat

Powdercoat MB4092

Memo

1.19

Powder Coating

START TIME: 8:40.
OVEN TEMPERATURE: 320°
FINISH TIME: 9:10.

10 1706-14

DAS
34
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Misidentified ☐	Past Due ☐																																																														

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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

10

DAS
38
9-89

JUN 14 2017

160

Identify as per dwg & Stock Location: WA 3 0.00***160***

Packaging

Memo

0.00

Packaging

JUN 14 2017

JUN 14 2017

CPC

170

QC21- Final Inspection - Work Order Release 0.00

170

QC

Memo

0.00

Quality Control

17/6/14

JUN 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

Friday, May 05, 2017 9:44:37 AM

Page 1

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160905

Parent Item: PB67-43001-261

PR67-43001-261

Parent Item Name: Lever Arm

Start Date: 5/16/2017

Required Date: 5/22/2017

Start Qty: 28.00

Required Qty: 28.00

Comments: IPP A05.06.07New issueKJ/JLM
IPP Rev:B 08-06-23 now made on water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.250		Purchased		No		100	sf	9.1000	0.693	20.42526			

M6061T6S 250

6061T6 SHEET .250

OK 17/05/31

Location

Loc Qty

Loc Code

MAT020

9.1

m131352

9.1

137515

26

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

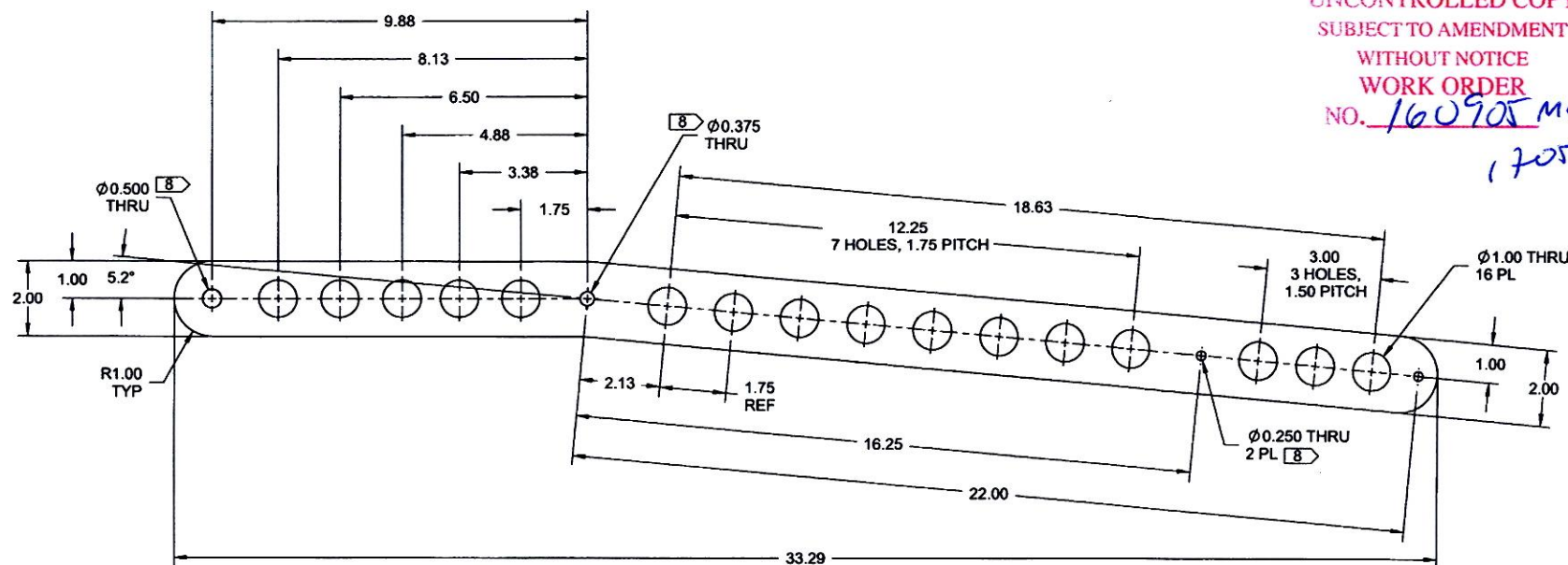
QA Closed: _____ Date: _____

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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 160905 MLC
170505



B67-43001-261 LEVER ARM

RELEASED
2009-09-24
MD

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF. DART SPEC. M6061T6S 250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.29 lbs
- 8) MASK PRIOR TO POWDER COAT

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 39 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.03.11
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO. B67-43001-261	REV. C	
MFG. APPR.			SHEET 1 OF 1	
APPROVED		TITLE LEVER ARM	SCALE	
DE APPR.	N/A		NTS	
DATE	09.03.11	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		